

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011540**Date Inspected:** 05-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) longitudinal linear indication measuring approximately 20mm in length.
- The welds are identified as: SSD10-PP56-108, 109.
- The welds are a Fillet Weld type joining the Bottom Plate (BP92A) to Floor Beam (FB-5B) web plate.
- The approved weld drawings, detailed these weld as fracture critical weld (FCW).
- The OBG 7DW segment is located at outside yard.

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

For further information, please see the attached pictures below. Please see incident report on this date.

Segment 7DW

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

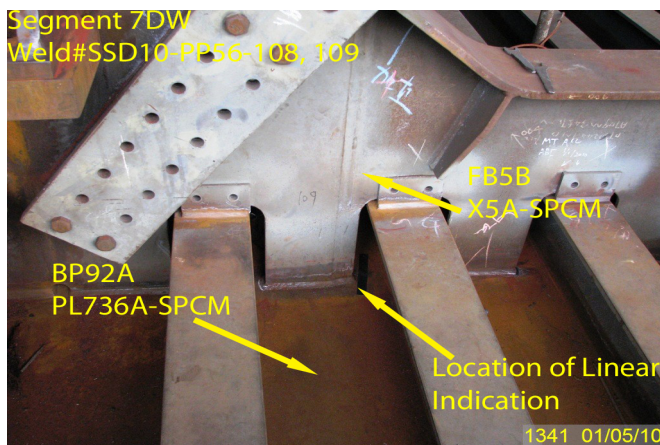
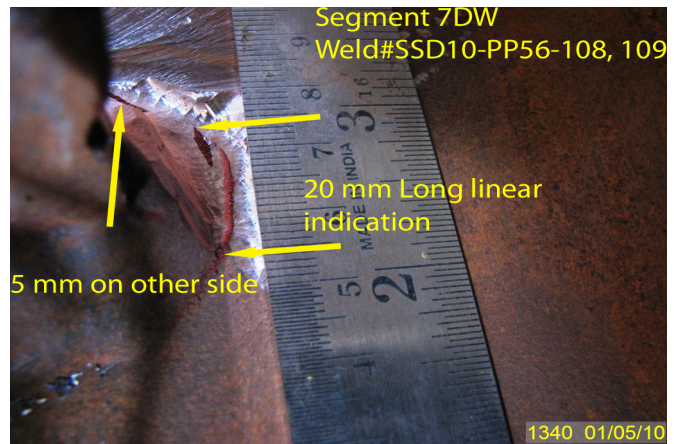
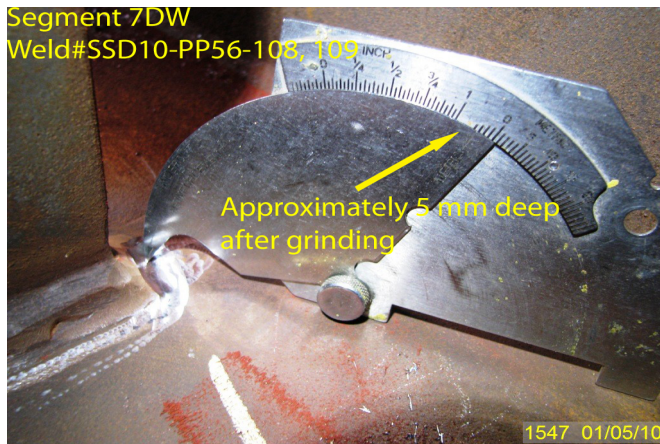
-(SSD10-PP56-106, 107, 110, 047, 048, 049, 050)

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- (SSD10-PP56-220, 224, 225, 228, 229, 221)
- (SSD10-PP56-240, 241, 244, 245, 248, 249)
- (SSD10-PP56-234, 235, 238, 239, 254, 255, 258, 259)
- (SSD11-PP57-106, 107, 108, 110, 047, 048, 049, 050)
- (SSD12-PP58-109, 110, 111, 112, 113, 048, 049, 050, 051)
- (SSD21-PP55.5-049, 050, 051, 052)
- (SSD22-PP56.5-049, 050, 051, 052)
- (SSD22-PP57.5-049, 050, 051, 052)
- (SSD10-PP56-108, 109, 111)- Rejectable indication found.
- (SSD11-PP57-109, 111)- Rejectable indication found.
- (SSD12-PP58-114)- Rejectable indication found.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Patel,Hiranch	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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